

Date: Monday, 2/4/2008 11:28:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK BASE
Job Number : 37187	
Estimate Number : 11361	
P.O. Number :	Part Number : D33703
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3370 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By : <u> </u>	Due Date : 2/15/2008 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est. B-05.05.25 Added Powder Coat KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.5" x 2.5"
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Comment: Qty.: 0.3657 f(s)/Unit Total : 2.9257 f(s)
 6061-T6 Bar 1.5" x 2.5"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B1.500x02.500)
 Identify for D3370-3
 Batch: 1110974

ML 08/02/07

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank: 1.500" x 2.500" x 4.120" long

ML 08/02/07

13

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3370-3 as per Folio FA482 and Dwg D3370
 Identify as D3370-3
 Dwg Rev: _____

SA 08/02/11

13

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/02/11

13

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 08/02/11

13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3370-3 PAR #: NA Fault Category: Prod / Machine NCR: (Yes) No DQA: D Date: 08/02/19
 QA: N/C Closed: A Date: 08/02/19

NCR: <u>37187</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	<u>3.0</u>	<u>2 part scrap</u> <u>to wrong insert tool in</u> <u>setup</u> <u>1- wrong Drill 420's instead of 185</u> <u>2- wrong channel tool</u>	<u>[Signature]</u>	<u>Scrap and Destroy</u> <u>and Replace</u> <u>(Qty x2)</u>	<u>[Signature]</u> <u>08/02/11</u>	<u>[Signature]</u> <u>08/02/11</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:28:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 37187

Part Number: D33703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(13)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

VR 08-02-12

7.0

POWDER COATING

POWDER COATING



M 18052



(13X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M-L 08/02/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HO



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-15

(13X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST492

AS 08/02/12

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/15

Job Completion



U 08-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37187
Description: Pedal Lock Cover		Part Number:	D3370-3
Inspection Dwg: D3370 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

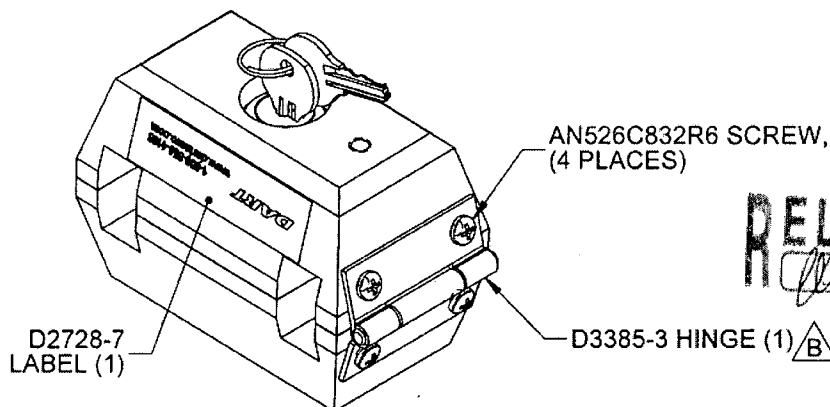
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.003	/			
3.344	+/-0.010	3.342	/			
0.592	+/-0.010	.591	/			
0.202	+/-0.010	.200	/			
Ø1.000	+0.005/-0.000	Ø1.002	/			
0.25	+/-0.030	.25	/			
0.283	+/-0.010	.283	/			
2.000	+/-0.010	2.000	/			
0.300	+/-0.010	.300	/			
0.550	+/-0.010	.555	/			
1.50	+/-0.030	1.500	/			
Ø1.250	+0.005/-0.000	Ø1.250	/			
0.635	+/-0.010	.635	/			
Ø0.750	+0.010/-0.000	.758	/			
1.673	+/-0.010	1.670	/			
0.430	+/-0.010	.430	/			
2.638	+/-0.010	2.637	/			
2.35	+/-0.030	2.350	/			
0.715 deep	+/-0.010	.720	/			
15°	+/-0.1°	15°	/			
0.19 x 45°	+/-0.030	.19 x 45°	/			
0.450	+/-0.010	.450	/			
1.450	+/-0.005	1.450	/			

Measured by:	SA	Audited by:	S.F.	Prototype Approval:	N/A
Date:	08/02/09	Date:	08/02/11	Date:	N/A

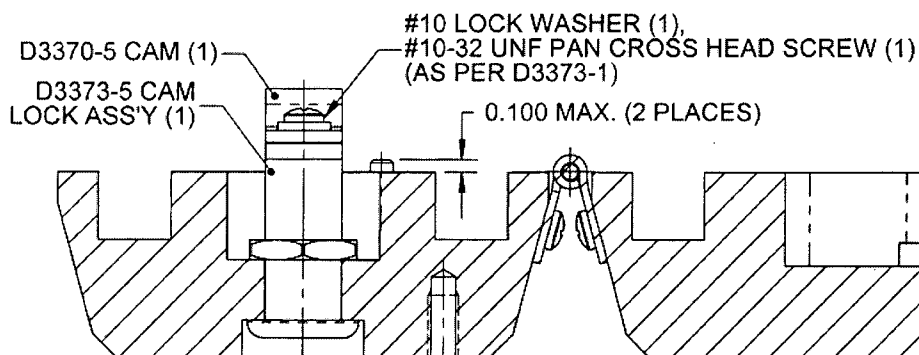
Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	



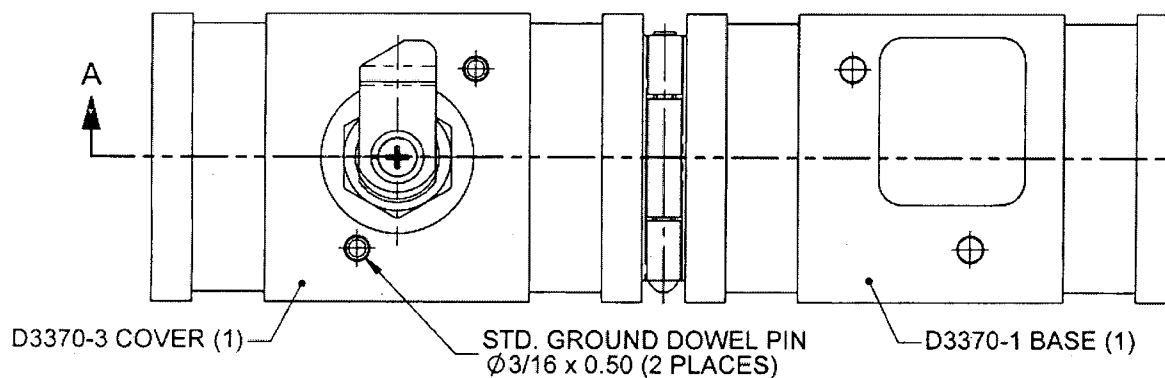
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CHECKED H	APPROVED [Signature]	DRAWING NO. D3370	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:1.5
A	04.12.15	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3370-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

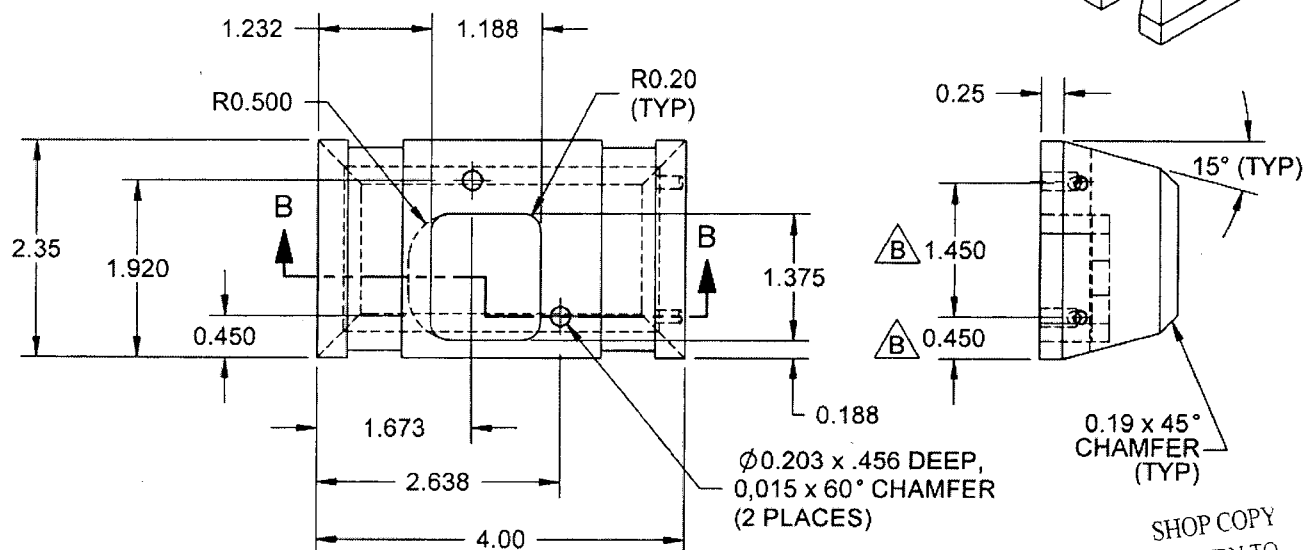
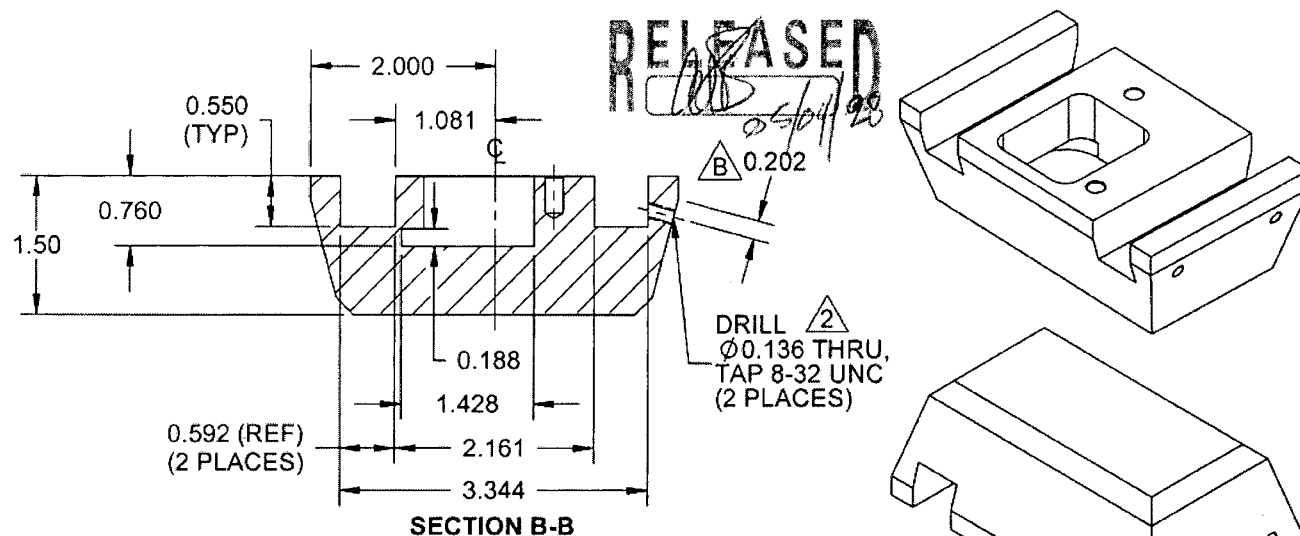
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NO 37187



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 77	APPROVED 13	DRAWING NO. D3370	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3370-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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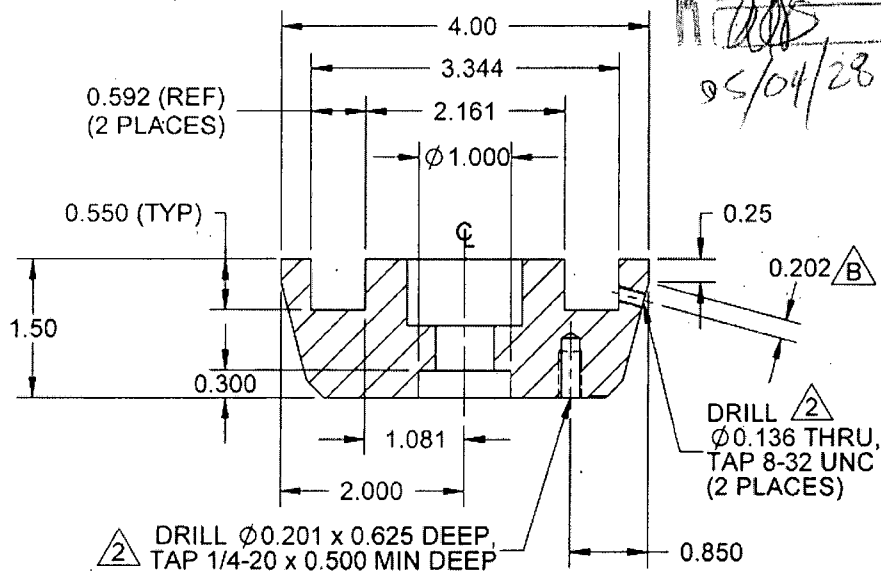
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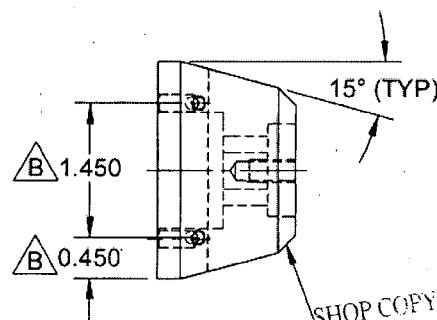
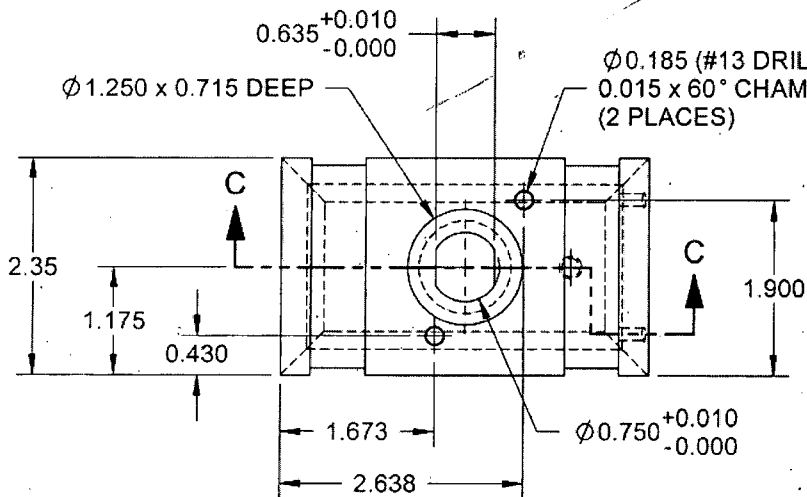
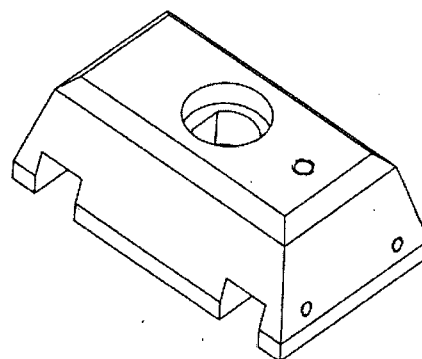
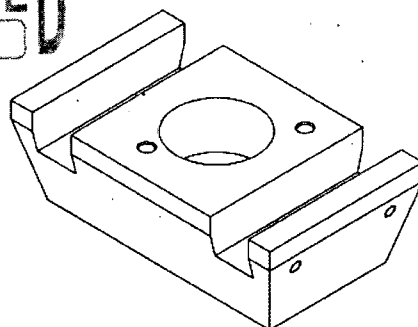


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3370	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2

RELEASED
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05/04/28



SECTION C-C



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WORK ORDER
NO. **37187**

D3370-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

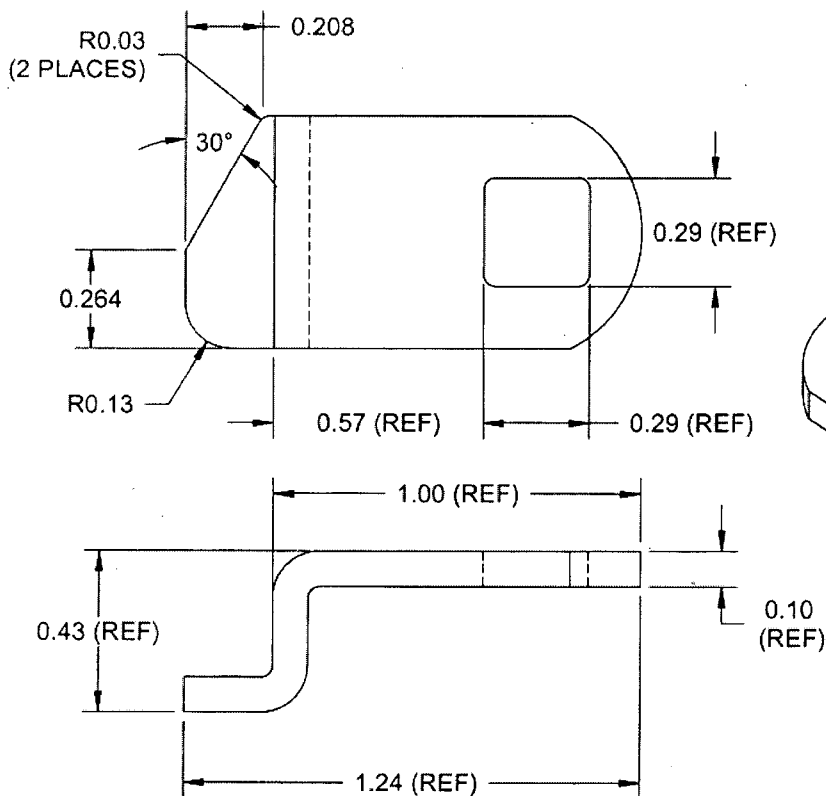
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3370	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



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NO. 37187

D3370-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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